

Date: Wednesday, 1/24/2007 4:51:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B AFT X-TUBE
Job Number : 30442	
Estimate Number : 12347	
P.O. Number : N/A	Part Number : D206667201
This Issue : 1/24/2007 S.O. No. : N/A	Drawing Number : D206-667-241 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : B
Previous Run : 30441	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/28/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature] 07.01.25</u>	
Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



①

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG002

K-S 07.02.09

2.0	D6003102	Crosstube
-----	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1- D6003-102 Crosstube B23767

Check OD = 2.250"; ID = 1.380"

SD 07.02.07

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

SD 07.02.07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

SD 07.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

H:\FORMS\Quality Ass

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Drawing Name: 206B AFT X-TUBE

Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

Inside of Cuff(Donot engrave on outside of tube)

SA 07-02-08

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 07-02-08

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07-02-08

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

SA 07-02-19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07-02-19

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SA 07-02-19

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

EL 7-5-8

W/O:		WORK ORDER CHANGES					
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Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



2-7-05-16 *Q*



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

2-6-18
EL

JD 2-6-18

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-6-18

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2-7-06-20 *Q*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/ 2-7-06-20 *Q*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4012

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

Col 7/06/21 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

1/24/26 (1)

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

1/24/27 (21)

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

07-06-28

21.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

07 06 29 (1)

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total: 1.3525 f(s)

Pick:

Qty Part number Description

Batch

2 D2856-400(Cut to 7.73")

Abrasion Strip

32020

07 07 27

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206B AFT X-TUBE

Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2891-1

Support

26715

~~22228~~

ml 07 07 22

24.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-2270

Clamp

104902

ml 07 07 22

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

ml 07 07 22

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/07/24

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

M104885

29.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2872-043

Nut Plate

B28918

ml 07/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206B AFT X-TUBE

Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2872045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-045 Nut Plate B28919 ✓

31.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 AN5-10A Bolt M104936 ✓

32.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 AN5-30A Bolt M19522 ✓

33.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

20 AN960JD516 Washer M104156 ✓

34.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 MS21042L5 NUT M104118 ✓

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 01/07/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 30442

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location:

PPP Rev:

B

6/2/20 (1)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/26 (1)

Job Completion



U 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30442
Description: Crosstube Assembly	Part Number:	D206-667-241
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

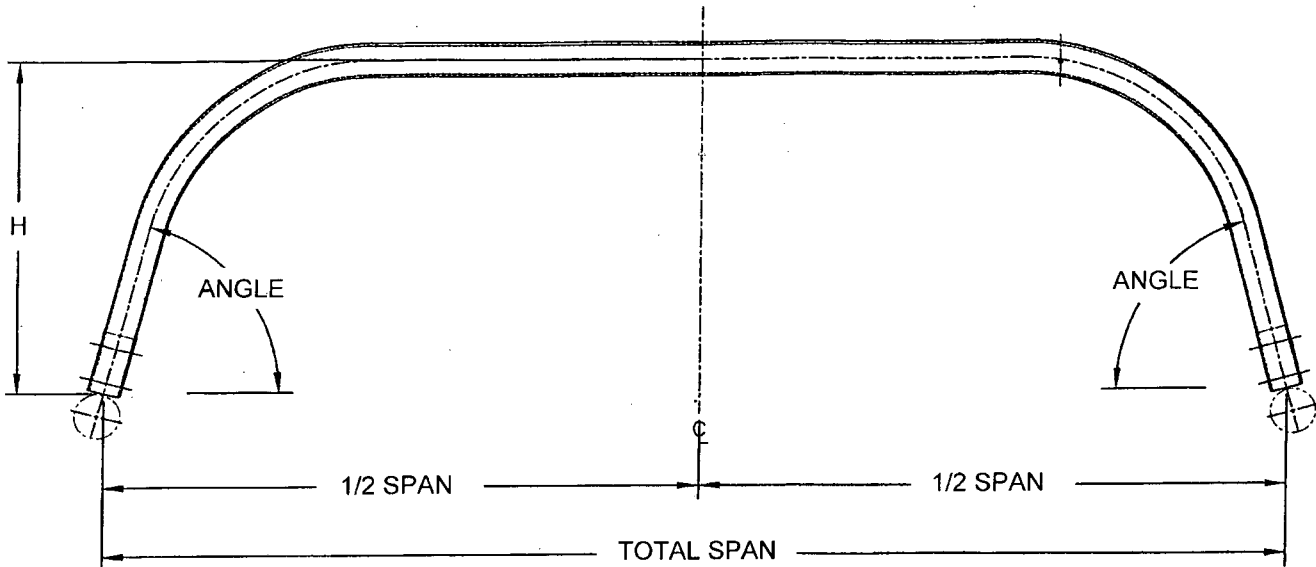
☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	30° x 500	/		
	0.250	+/-0.010	0.250	/		
	2.240	+0.005/-0.000	2.242	/		
	4.438	+/-0.030	4.440	/		
	1.780	+0.005/-0.000	1.785	/		
	R0.063	+/-0.010	R.063	/		
	1.851	+0.005/-0.000	1.855	/		
	1.928	+0.005/-0.000	1.932	/		
	2.005	+0.005/-0.000	2.009	/		
	2.082	+0.005/-0.000	2.087	/		
	2.159	+0.005/-0.000	2.163	/		
	2.190	+0.005/-0.000	2.195	/		
SIDE B	30° x 0.500	+/-0.010	30° x 500	/		
	0.250	+/-0.010	0.250	/		
	2.240	+0.005/-0.000	2.242	/		
	4.438	+/-0.030	4.440	/		
	1.780	+0.005/-0.000	1.784	/		
	R0.063	+/-0.010	R.063	/		
	1.851	+0.005/-0.000	1.855	/		
	1.928	+0.005/-0.000	1.932	/		
	2.005	+0.005/-0.000	2.0085	/		
	2.082	+0.005/-0.000	2.087	/		
	2.159	+0.005/-0.000	2.163	/		
	2.190	+0.005/-0.000	2.194	/		
	100.60	+/-0.020	100.60	/		

Measured by: SD	Audited by: ml	Prototype Approval:	N/A
Date: 070208	Date: 07/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	B

Crosstube Bend Dimension Sheet



PART NUMBER: _____

BATCH NUMBER: 30442

DRAWING: _____ REVISION: _____

H: _____

1/2 SPAN: _____

TOTAL SPAN: _____

ANGLE: _____

QC 15: _____

DATE: _____

QTY: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 #

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

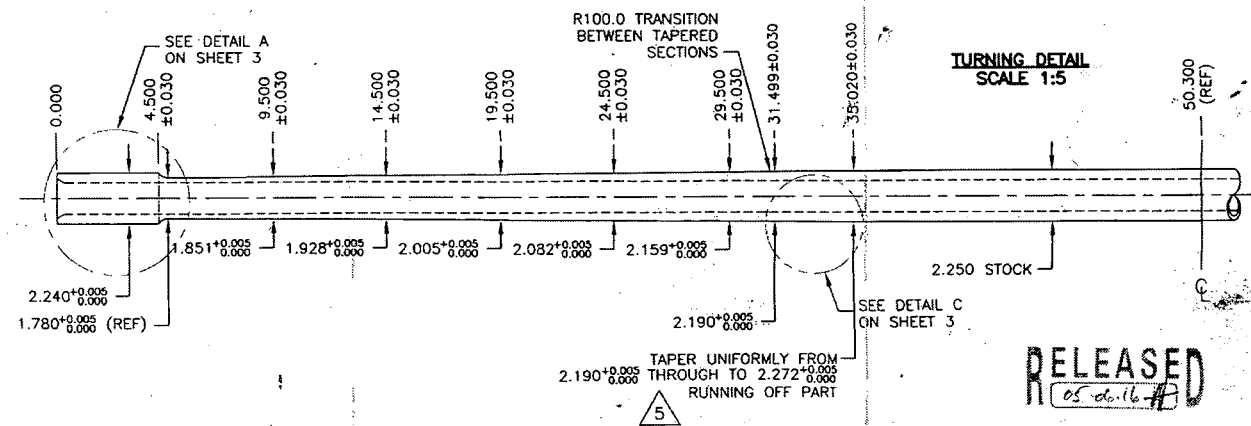
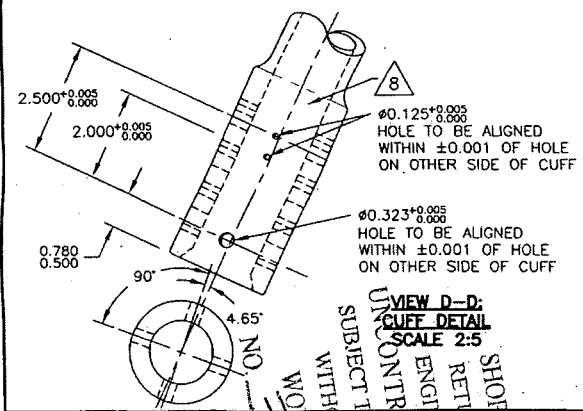
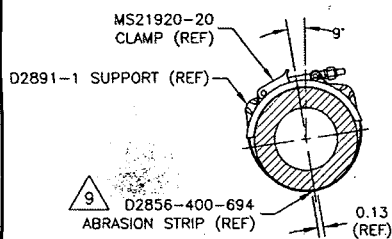
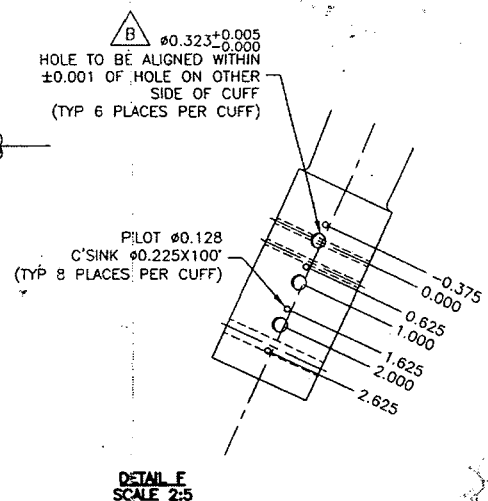
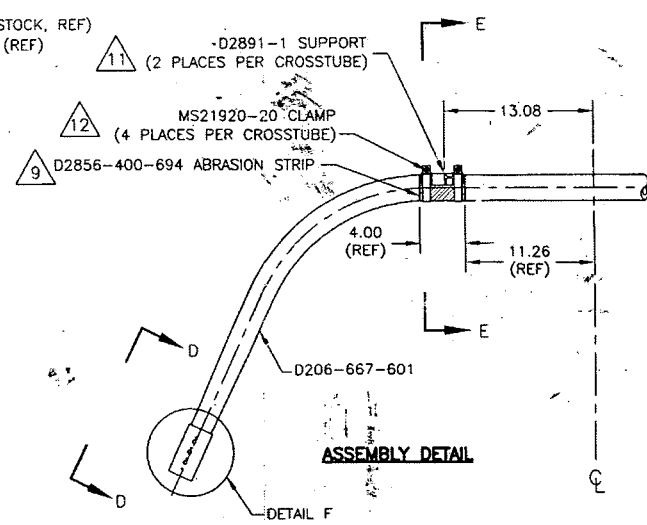
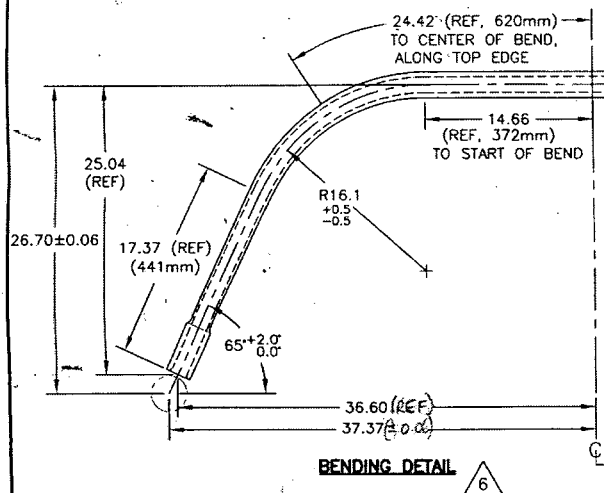
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30442

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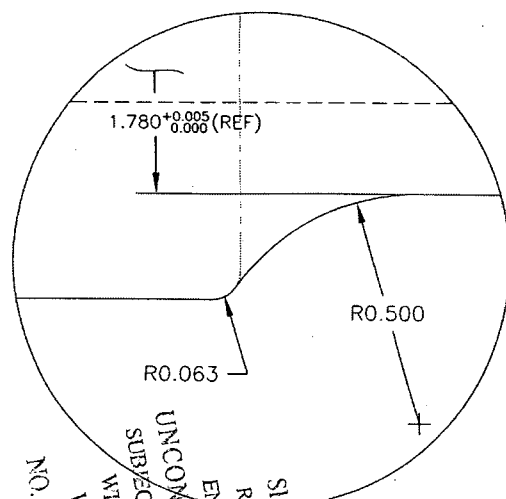
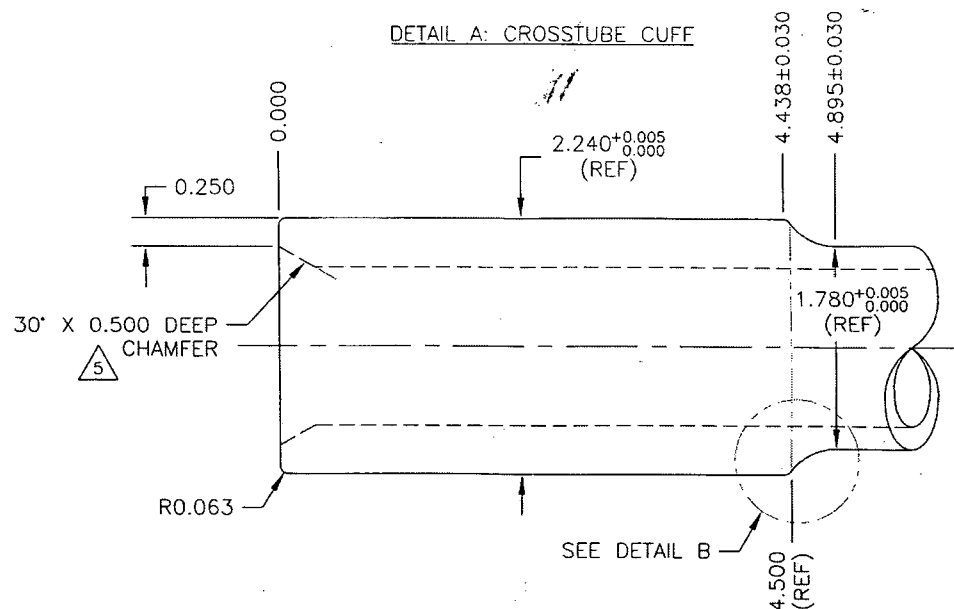
RELEASED
05 Dec 16

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	APPROVED	DRAWING NO. D206-667-241	REV. B SHEET 2 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT)		SCALE 1:10	

SHOOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
20442

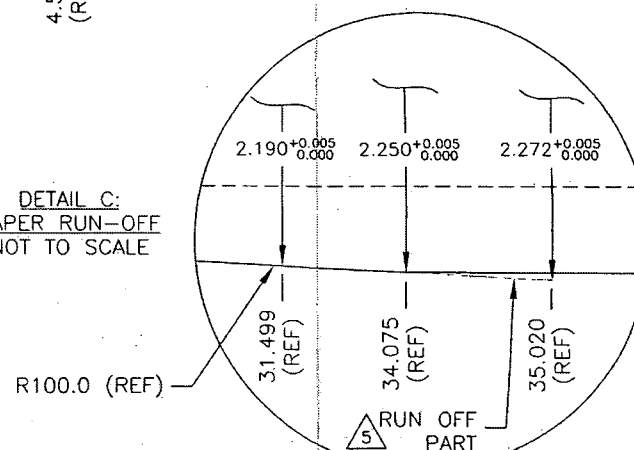
RELEASED
05-06-16-4

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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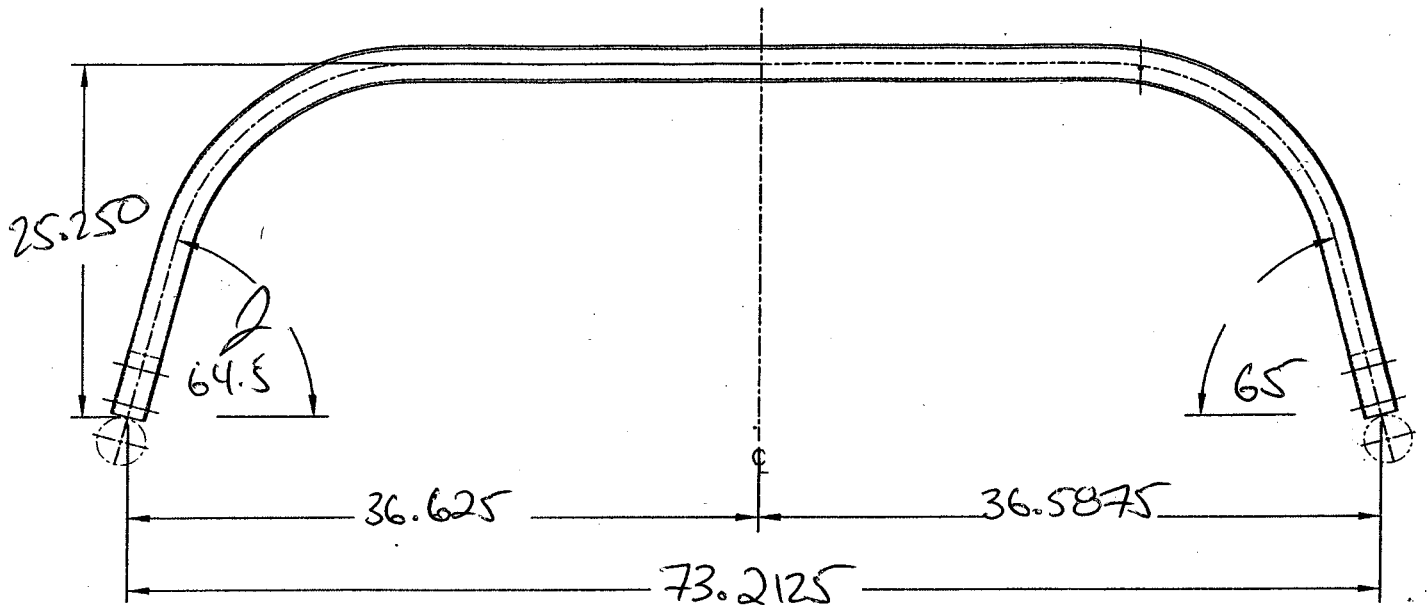
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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. 0206-667-241	REV. B SHEET 3 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	SCALE 1:1	

NO. 30442
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHIP COPY

DART AEROSPACE LTD		Work Order:	30442
Description: Crosstube High Aft (206B)		Part Number:	D206-667-201
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1	

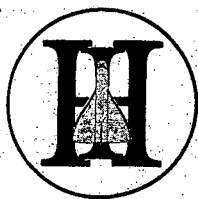
Required Dimension	Min	Max
Height	24.48	25.10
1/2 Span	36.54	36.66
Angle	65	67
Total Span	73.08	73.32



Comments
Length is over by .021 from nominal. 0.005 over tolerance.

QC15 Inspection	 0705-16
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36755

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (16) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D206-667-201 S/N's B30318, B30442 & B30441

Qty (4) P/N D206-667-203BL S/N's B32672, B32458, B32671 & B32457

Qty (1) P/N D407-667-205 S/N B31040

Qty (1) P/N D206-667-201 S/N B30440

Qty (4) P/N D212-664-201 S/N's B32148, B32146, B32149 & B32147

Qty (3) P/N D206-667-103BL S/N's B32667, B32455 & B32456

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (16) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

All (16) cross tubes passed inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLECHER
S. FLECHER

DATE June 22, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

ADDRESS:

P.O. NUMBER

4012

CONTACT NAME:

Chantel

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT